

40
(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets

(11) Publication number:

0 063 103

A1

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 82830072.3

(51) Int. Cl.³: B 21 H 1/06

(22) Date of filing: 25.03.82

(30) Priority: 13.04.81 IT 6750681

(43) Date of publication of application:
20.10.82 Bulletin 82/42

(84) Designated Contracting States:
AT BE CH DE FR GB IT LI LU NL SE

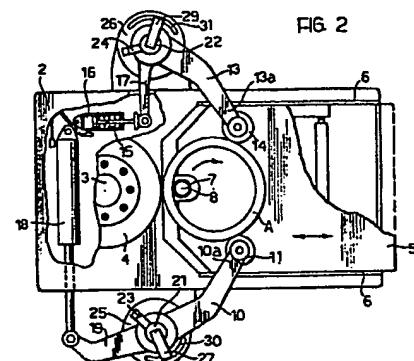
(71) Applicant: HS HYDRAULIC SYSTEMS S.r.l.
Via Gradisca 50/Int. 12
I-10136 Torino(IT)

(72) Inventor: Ciccorelli, Raffaele
Via Oropa 114 bis
I-10153 Torino(IT)

(74) Representative: Jacobacci, Filippo et al,
c/o JACOBACCI-CASETTA & PERANI S.n.c. Via Alfieri, 17
I-10121 Torino(IT)

(54) A ring rolling mill.

(55) A ring rolling mill comprising a driven working roll (4) a rotary mandrel (7) serving as a counter-roll, and a containment roller (11) carried by a pivoted arm (10) and able to engage laterally the ring (A) being rolled, further includes a tracer roller (14) carried by a respective pivoted arm (13). The assembly formed by the tracer roller (14) and its respective arm (13) is a mirror image of the assembly formed by the containment roller (11) and its respective arm (10) across the vertical plane identified by the axes of rotation of the working roll (4) and of the mandrel (7), which are both vertically orientated. Means (21, 22) for detecting the angular position of the tracer arm (13) and of the containment arm (10) are connected to an electrical control circuit (32) of an hydraulic servo valve (34) for regulation and locking of the angular movement of the containment arm (10) so as to maintain the containment roller (11) in a symmetrical position with respect to the tracer roller (14) across the vertical plane.



"A ring rolling mill".

The present invention relates to ring rolling mills of the type comprising:

- a driven working roll with a fixed vertical axis,
- 5 - a table movable towards and away from the roll,
- a vertical-axis rotary mandrel carried by the table and serving as a counter-roll, about which the ring is disposed in such a way that it rests on the table and is rolled between the roll and the mandrel, the axes of the roll and of the mandrel lying in a vertical plane parallel to the direction of movement of the table,
- a containment roller having a vertical axis 15 and operable to laterally engage the ring during rolling,
- an arm pivotable about a vertical axis, which carries the said roller at a free end, and
- 20 means for making the containment arm rotate in such a sense as to displace the containment roller from the said vertical plane gradually as the diameter of the ring increases upon rolling.

In ring rolling mills of the type specified above there is a problem in maintaining the containment roller in engagement with the outer surface of the ring being worked.

In prior art ring rolling mills, the movement of the pivoted arm which carries the containment roller is controlled, by means of a kinematic mechanism including

a cam, by the rotation of the working roll. In this way, the displacement of the containment roller is controlled in dependence on the time elapsed from the beginning of the rolling operation. This is unsatisfactory inasmuch as the increase in diameter of the ring by the effects of the rolling does not follow an exact law and can vary within wide limits as a function of the conditions in which the rolling operation is performed, and as a function of the intrinsic characteristics of the material of the ring subject to rolling.

There can thus occur situations in which displacement of the containment roller with respect to the plane identified by the axes of rotation of the working roll and of the mandrel is insufficient, giving rise to conditions of juddering. In other cases the displacement of the containment roller is excessive: the ring is then free to pivot about the position defined by the nip between the working roll and the mandrel acting as counter-roll.

In both the above indicated situations the final product of the rolling operation is defective and must be scrapped.

The object of the present invention is to provide a ring rolling mill of the above identified type, which does not have the above indicated disadvantages.

With a view to achieving this object, the subject of the present invention is a ring rolling mill of the type specified above, characterized by the fact that it includes:

- a tracer arm pivoted about a vertical axis

which is a mirror image of the said containment arm across the said vertical plane and is resiliently biased towards this plane,

5 - a tracer roller having a vertical axis, carried by the said tracer arm and having the same diameter as the containment roller,

- a pair of angle sensors, each sensitive to the angular position of a respective containment or tracer arm, and

10 - a control circuit supplied with signals produced by the angle sensors and operable to control the said means for making the containment arm turn in such a way as to maintain the containment roller in a symmetrical position with respect to the tracer roller
15 across the said vertical plane.

Owing to this characteristic, the containment roller is constantly maintained in lateral engagement with the ring being rolled, preventing the occurrence of the phenomena of juddering or of free oscillation
20 previously described.

The advantages deriving from the invention will become apparent from the following description, given with reference to the attached drawings provided by way of non limitative example, and in which:

25 - Figure 1 is a perspective view of the upper portion of the ring rolling mill according to the invention,

- Figure 2 is a plan view, partially sectioned, of the rolling mill,

30 - Figure 3 is a schematic representation of

the electrical and hydraulic control and regulation system of the rolling mill, and

- Figure 4 is a block diagram showing the inner structure of one of the elements of Figure 3.

5 In Figure 1, there is generally indicated a base 1 which carries at its upper end a working plane 2 on which the working roll 4 is rotatably mounted about a vertical axis 3. The working surface 2 includes a table 5 movable towards and away from the roll 4 along a 10 pair of guides 6. The table 5 carries a mandrel 7 freely rotatable about a vertical axis 8. The mandrel 7 serves as a counter-roll in the operation of rolling a ring A disposed about the mandrel 7 and resting on the table 5.

15 Normally, the lateral surface 4a of the working roll 4 and the lateral surface 7a of the mandrel 7 have profiles which are respectively complementary to the profiles of the outer and inner surfaces of the ring A.

Mounted about a vertical shaft 9 carried by the 20 support 1 there is a pivoted arm 10 which carries at its free end 10a a containment roller 11 operable to engage the ring laterally during rolling. The containment roller 11 acts on the semi-circle of the ring A which, with reference to the direction of rotation of 25 the ring A, is located in advance of the portion of the ring A lying between the roll 4 and the mandrel 7 during the rolling operation which is performed, in the case illustrated, by making the ring A turn in a clockwise sense.

30 In a mirror image position with respect to the

arm 10 and the containment roller 11, across the vertical plane identified by the axes of rotation 3 and 8, there is rotatably mounted, about a shaft 12 carried by the base 1, a second pivoted arm 13 which carries 5 at its free end 13a a roller 14 having the same diameter as the containment roller 11 and which serves as a mechanical tracer.

The pivoted arm 13, which carries the tracer roller 14, is resiliently biased in engagement with the 10 ring A being rolled by resilient means constituted by a helical spring 15 contained in a single-acting hydraulic cylinder 16 arranged below the working plane 2 and the piston rod of which is connected with the tracer arm 13 by means of a connecting rod 17.

15 The force exerted by the spring 15 can be opposed by the action of the hydraulic cylinder 16, which serves to make the arm 13 turn outwardly of the movable table 5 in such a way as to space the tracer roller 14 from the position of engagement with the ring A, for 20 example, to permit the insertion of the ring between the roll 4 and the mandrel 7 at the beginning of the rolling operation.

The turning of the containment arm 10 about the shaft 9 is controlled by a double-acting hydraulic actuator 18 arranged below the working plane 2, by means 25 of an arm 19 rigidly connected with the arm 10 for rotation about the shaft 9.

The rolling mill according to the invention further includes means (not illustrated) for control of 30 the movement in a horizontal sense of the movable table

5 towards and away from the roll 4. In the position of maximum spacing from the roll 4, the table 5 can be tipped up about a horizontal shaft 20 in such a way as to permit automatic discharge of a ring which has been 5 subjected to a rolling operation.

In axially aligned positions with respect to the shafts 9 and 12 there are mounted two angle sensors 21, 22 which are sensitive, respectively, to the angular position of the containment arm 10 and that of the 10 tracer arm 13. In the embodiment illustrated, each angle sensor 21, 22, which can be of the potentiometric type or of the type known in the relevant technical literature as an "angle encoder", comprises a rotary portion connected by means of a respective bracket 23, 24 15 to a flange 25, 26 rigidly connected with the respective arm 10, 13, and a stator portion connected by means of another bracket 27, 29 with the base 1 of the rolling mill.

Preferably, each of the flanges 25, 26 has arcuate 20 slots 30, 31 traversed by the brackets 27 and 29.

The angle sensors 21, 22 may be provided with angle multipliers, for instance angle multipliers of the gear type.

The electrical signals produced by the angle 25 sensors 21, 22 are supplied to a control circuit 32, having the inner structure shown in detail in Figure 4.

In Figure 4, 33 designates a comparator circuit controlling a solenoid valve 34 which acts on the hydraulic actuator 18 to control the movement of the 30 containment arm 10.

As soon as the comparator 33 detects the existence of a difference between the position of the containment roller 11 with respect to the vertical plane identified by the axes of rotation 3 and 8 and the position, with respect to the same plane, of the tracer roller 14, the solenoid valve 34 is acted upon in such a way that the hydraulic actuator 18 re-establishes the conditions of mirror-symmetry of the containment roller 11 and the tracer roller 14 with respect to the said plane.

Preferably, the comparator circuit 33 is of the threshold type with hysteresis for the purpose of preventing the occurrence of uncontrolled oscillation phenomena in the automatic circuit for regulation of the position of the containment arm 10.

By 35 is designated an arithmetic circuit which is supplied with the signals produced by sensors 21, 22 and which produces at its output a signal corresponding to the average of the two input signals.

20 The average signal provides an indication of the diameter of the ring A being rolled.

It should be pointed out that each one of the signals produced by sensors 21, 22 provides an indication of such diameter, since this diameter is positively identified by the angle formed by each one of the arms 10, 13 with respect to the vertical plane identified by the axes of rotation 3 and 8.

30 The averaging operation allows however a more precise signal to be obtained which is not influenced by slight dissymmetries which may instantaneously re-

sult in the positioning of ring A with respect to the said plane.

The signal produced by circuit 35 is supplied to a threshold circuit 36, where this signal is compared 5 with a signal level corresponding to a diameter value which was previously selected by acting on a potentiometric selector, such as a digital switch 37.

In addition to the solenoid valve 34, the threshold circuit 36 controls a second solenoid valve 38 10 which acts on the hydraulic cylinder 16 and controls the outward movement of the tracer arm 13.

When the average value of the signals produced by the angle sensors 21, 22 reaches the reference level set in selector 37, the threshold circuit 36 acts on 15 the solenoid valves 34, 38 to cause outward turning of the arms 10, 13 to space the containment roller 11 and the tracer roller 14 from the engagement position with ring A.

At this point the rolling process is terminated 20 and ring A can be removed from table 5.

CLAIMS:

1. A ring rolling mill of the type comprising:

- a driven working roll with a fixed vertical

axis,

- a table movable towards and away from the

5 roll,

- a rotatable mandrel with a vertical axis

carried by the table and serving as a counter-roll, and

about which the ring is arranged in such a way that it

rests on the table and is rolled between the roll and

10 the mandrel, the axes of the roll and the mandrel lying

in a vertical plane parallel to the direction of move-

ment of the table,

- a containment roller with a vertical axis,

operable to laterally engage the ring being rolled,

15 - an arm pivoted about a vertical axis, which

carries the said roller at a free end, and

- means for making the containment arm turn in

the sense such as to displace the containment roller

from the said vertical plane gradually as the diameter

20 of the ring increases by the effect of rolling,

characterised by the fact that it comprises:

- a tracer arm (13) pivoted about a vertical

axis and which is a mirror image of the said contain-

ment arm (10) across the vertical plane and is resi-

25 lently biased towards this plane,

- a tracer roller (14) with a vertical axis,

carried by the said tracer arm (13) and having the same

diameter as the containment roller (11),

- a pair of angle sensors (21,22) each sensi-

tive to the angular position, respectively, of the containment arm (10) and tracer arm (13) and

- a control circuit (32) supplied with the signals produced by the angle sensors (21,22) and operable to control the said means (34,18) for making the containment arm (10) turn in such a way as to maintain the containment roller (11) in a symmetrical position with respect to the tracer roller (14) across the said vertical plane.
- 5 10 2. A ring rolling mill according to Claim 1, characterised by the fact that the said means for making the containment arm (10) turn comprise a double-acting hydraulic actuator (18) for control of the turning of the arm itself, and a servo valve (34) for commutation, regulation and locking of the movement of the actuator (18).
- 15 3. A ring rolling mill according to Claim 1 or Claim 2, characterised by the fact that it includes a hydraulic cylinder (16) operable to make the tracer arm (13) turn outwardly of the movable table (5) to space the tracer roller (14) from the engagement position with ring (A).
- 20 4. A ring rolling mill according to Claim 1, characterised by the fact that the angle sensors (21,22) are of an electro-mechanical type.
- 25 5. A ring rolling mill according to Claim 4, characterised by the fact that the angle sensors (21,22) are of a potentiometric type, are disposed in positions respectively aligned with the pivotal axes of the containment arm (10) and the tracer arm (13), and each in-

clude a rotor portion connected by means of a respective bracket (23,24) to a flange (25,26) rigidly connected with an associated arm (10,13) and a stator portion connected by means of another bracket (27,29) to 5 the base (1).

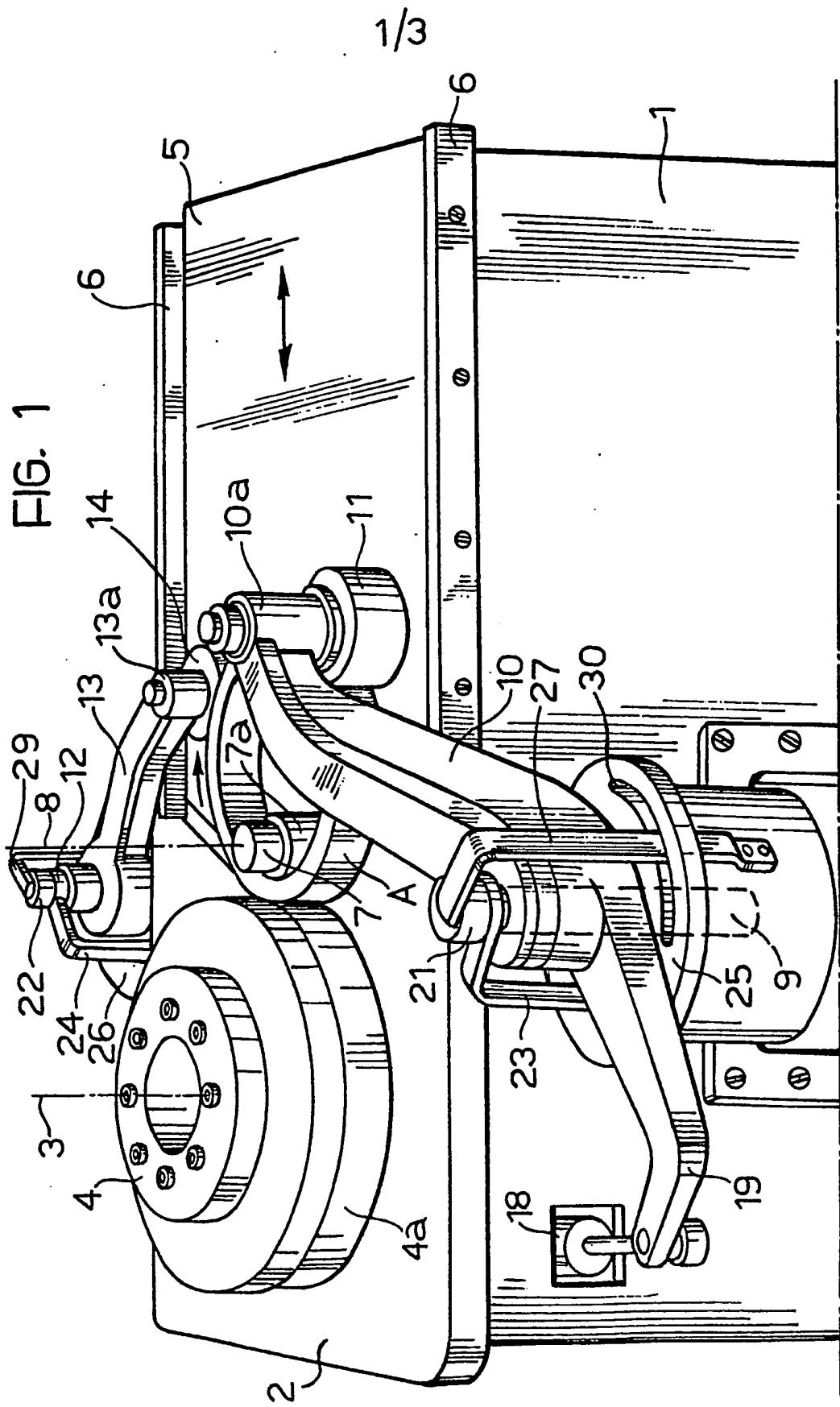
6. A ring rolling mill according to Claim 4 or Claim 5 characterised in that the angle sensors (21,22) are provided with angle multipliers of the gear type.

7. A ring rolling mill according to Claim 1, characterised by the fact that the control circuit includes 10 a comparator circuit of the threshold type with hysteresis (33).

8. A ring rolling mill according to Claim 3, characterised by the fact that it includes an arithmetic circuit 15 (35) to produce a signal corresponding to the average value of the signals produced by the angle sensors (21,22) and a threshold circuit (36) to compare said signal corresponding to the average value with a reference level and by the fact that said threshold circuit 20 (36) acts on said hydraulic actuator (18) and on said hydraulic cylinder (16) for disengaging the containment arm (10) and the tracer arm (13) from the engagement position with the ring (A) when the average value of 25 the signals produced by the angle sensors (21,22) reaches said reference level.

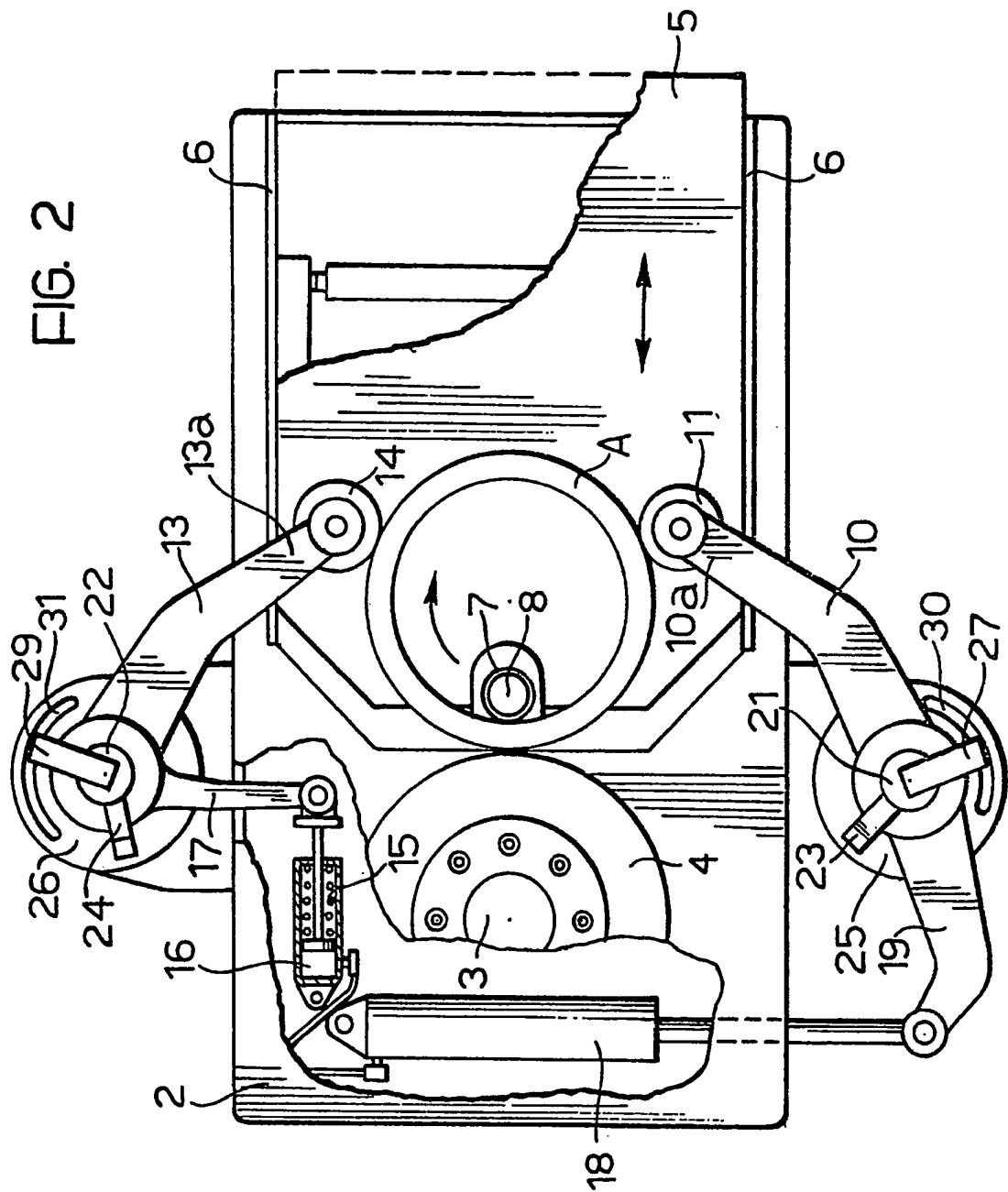
9. A ring rolling mill according to Claim 8, characterised by the fact that it includes means (37) for selectively setting said reference level in the threshold circuit (36).

FIG. 1



2/3

FIG. 2



3/3

FIG. 3

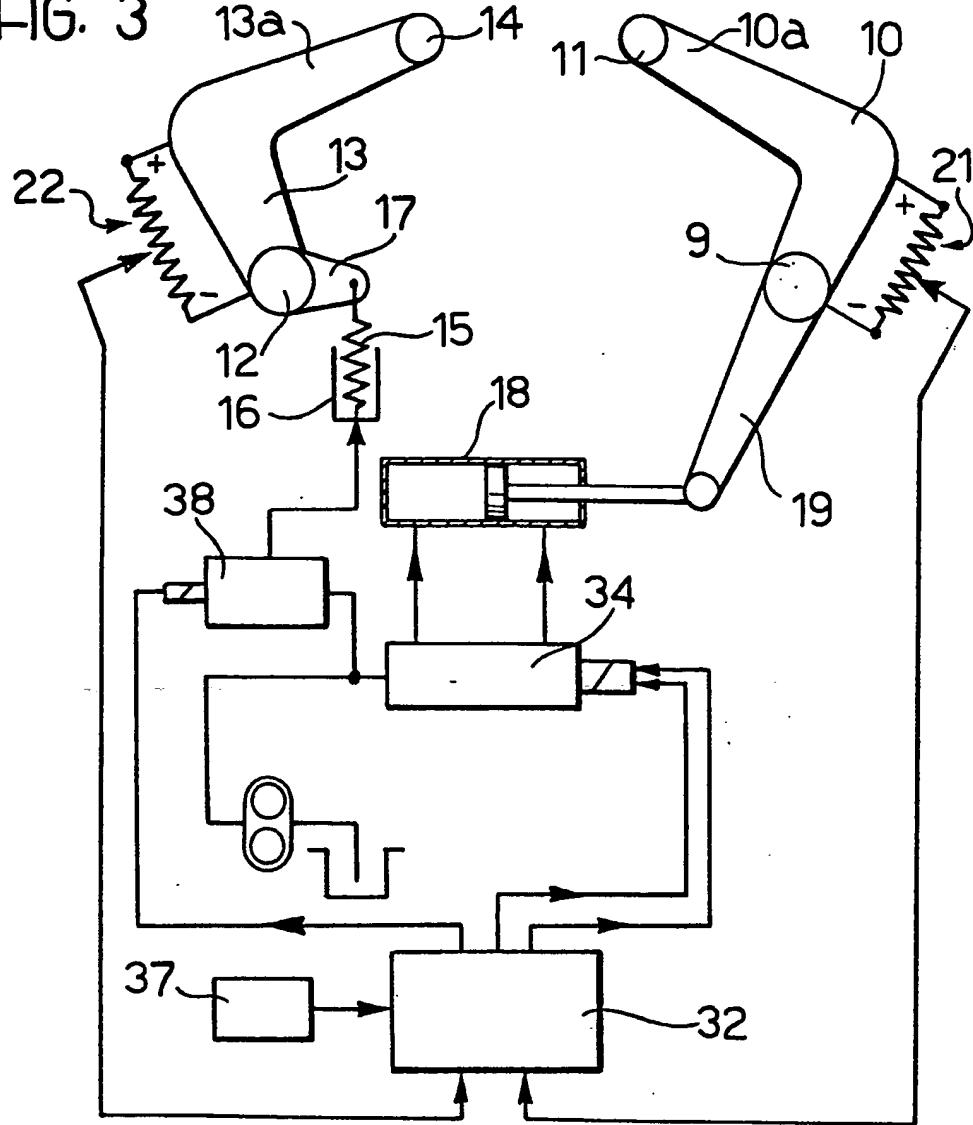
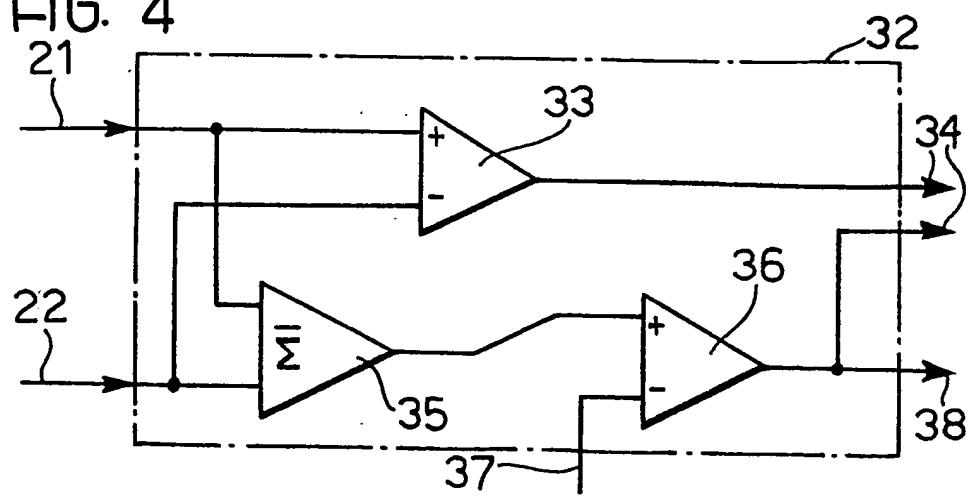


FIG. 4





European Patent
Office

EUROPEAN SEARCH REPORT

0063103

Application number

EP 82 83 0072

DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 3)
X	FR-A-2 183 987 (RHEINSTAHL) *Page 10; line 8 to the end; figure 4* & US - A - 3 824 820	1-4, 5, 8	B 21 H 1/06
A	DE-B-1 188 544 (ULRYCH) -----	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 3)
			B 21 H
The present search report has been drawn up for all claims			
Place of search THE HAGUE	Date of completion of the search 23-07-1982	Examiner SEMBRITZKI K.G.	
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	